

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021829**Date Inspected:** 16-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3020C-056 [Floor Beam (FB) 3348A to Side Panel (SP) 3124F, complete joint penetration (CJP) weld, at panel point (PP) 128.7-160]. The welder is identified as 047866 and was observed welding in 3G position. ZPMC Quality Control (QC) was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

The SMAW process on weld joint no: Seg3020AW-089 (SP3131A to SP3145B, CJP weld). The welders are identified as 037779 and 067520 and were observed welding in 2G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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OBG Seg 13CW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3015G-014 [FB3230A to Corner Assembly (CA) 3016A, CJP weld at PP123.5]. The welder is identified as 045143 and was observed welding in 3G position. ZPMC QC was identified as Zhang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 13BW and Seg 13CW:

The SMAW process on weld joint no: OBW13A-018 [Edge Plate (EP) to EP splice joint, CJP weld]. The welder is identified as 067764 and was observed welding in 4G position. ZPMC QC was identified as Zhang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U3b.

OBG Seg 13BW:

The SMAW process on weld joint no: Seg3014J-012 [Deck Panel (DP) diaphragm to DP diaphragm splice joint (DP3130A and Dp3131A), CJP weld at PP120.5]. The welder is identified as 066443 and was observed welding in 3G position. ZPMC QC was identified as Zhang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: Seg3014-009 (DP to CA, CJP splice weld). The welder is identified as 066261 and was observed welding in 4G position. ZPMC QC was identified as Zhang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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